

Thursday, 07/02/2008 11:11:40 AM  
Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Drawing Name : WEARPAD  
 Part Number : D35371  
 Drawing Number : D3537 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 28/02/2008  
 Qty: 100 Um: Each  
 Issue Number : 37292  
 Issue Date : 07/02/2008  
 S.O. No. :  
 Issue Rev. : NC  
 Issue Type : SMALL / MED FAB  
 Previous Run : 36714  
 Issued By :  
 Checked & Approved By :  
 Comment : Est Rev. A New Issue 07-02-14 JLM

Additional Product

Part Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 106860 RB 8-2-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C RB 8-2-12

Prog Rev: C

2-Deburr if necessary RB 8-2-12

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

05/02/12 129 56



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 37292

Part Number: D35371

Job Number: 

Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat m106834

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

PTD

08-03-19

(18)

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-19

(13)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/19

(18)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 08/03/24

(18X)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 08-03-24

(18)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR-20

SL 08-03-24

(18)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 08/03/25

Job Completion: 





U 08-03-25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

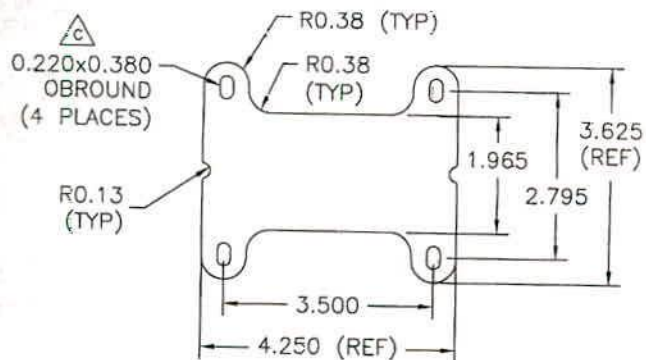
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-03- 19	6	-burnt through weapdate  RC Hammer action		-Scrap & destroy and replace <del>Bk</del> Qty (11) from pit	mf 08-03- 19			

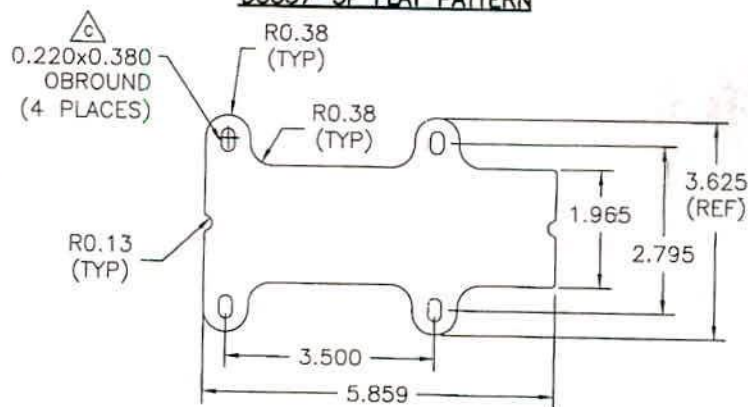
NOTE: Date & initial all entries



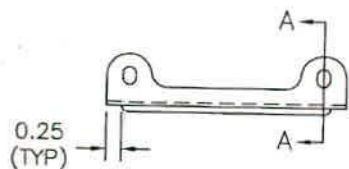
### D3537-1F FLAT PATTERN



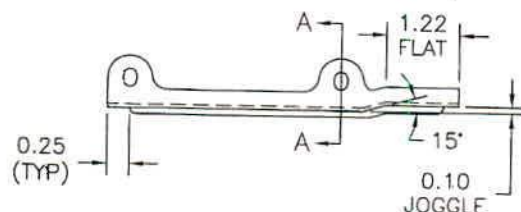
### D3537-3F FLAT PATTERN



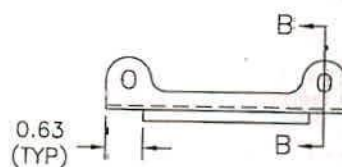
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



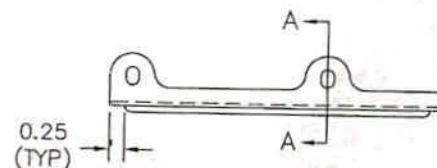
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



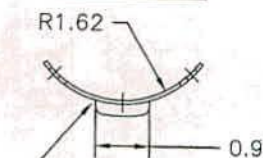
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

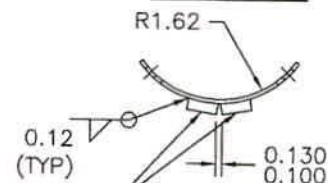


### SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

### SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

**RELEASED**  
07-05-08  
PER ECU  
952

### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. 6
		SHEET 1 OF 1
		SCALE 1:2

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, MA

